

628.022

Dart Aerospace Ltd.

Date: Wednesday, 10/3/2007 8:38:38 AM  
 User: Kim Johnston

## Process Sheet

44

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L /407 STEP ASSY, RH		
Job Number	: 34981A						
Estimate Number	: 11703						
P.O. Number	:			Part Number	:	D2724042	
This Issue	: 10/3/2007	S.O. No.	:	Drawing Number	:	D2724 REV C	
Prsht Rev.	:	NC		Project Number	:	N/A	
First Issue	:	/ /	Type	Drawing Revision	:	C	
Previous Run	:	33920A		Material	:		
Written By	:			Due Date	:	10/30/2007	Qty: 4 Um: Each
Checked & Approved By	:						
Comment	:	Est Rev:E	As Per Ecn 766	06-01-06	JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Qty	Part #	Description
	1	D2622-120C	Extrusion
			B 34016
		Check Material for any Dents or Defects	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Cut D2724-2 using D2622 extrusion as per Dwg D2724	
		Deburr and bevel ends for welding	
3.0	D2734	206 Step Endplate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		206 Step Endplate	
	Pick:		*
	Qty	Part Number	Description
	2	D2734	End Cap
			B 33861 = 3      B 34485 = 85
4.0	D34581	PLATE	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	2	D3458-1	Plate
			3 34179 = 6 B 35145 = 2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:38:38 AM  
User: Kim Johnston

35145

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34981A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch 34180 = 8

2 D3458-3 Plate

34180

10/07/15

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M103794  
M105058

Grind end cap welds flush

10/07/15

4

AM 07.10.16

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-16 (4)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/10/16 X4RH

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 07.10.16

4

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AM 07/10/16

4

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM 07/10/16

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

AM 07/10/16

Form: process

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:38:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34981A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT  
A/R AL ROD Batch: M103794

10/01-10-17 4

Grind end plate flush.

AM 07.10.17

(4)

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.10.17 (4)

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/18 +4RH

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

AM 07-10-18

X4RH

15.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 09-10-19

(4)

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ML 07 10 19

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M106030

(4)

Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

AM 07-10-25

44

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



LC 7/10/21

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 34981

LC 7/10/31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
--								

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:38:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34981A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.01 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



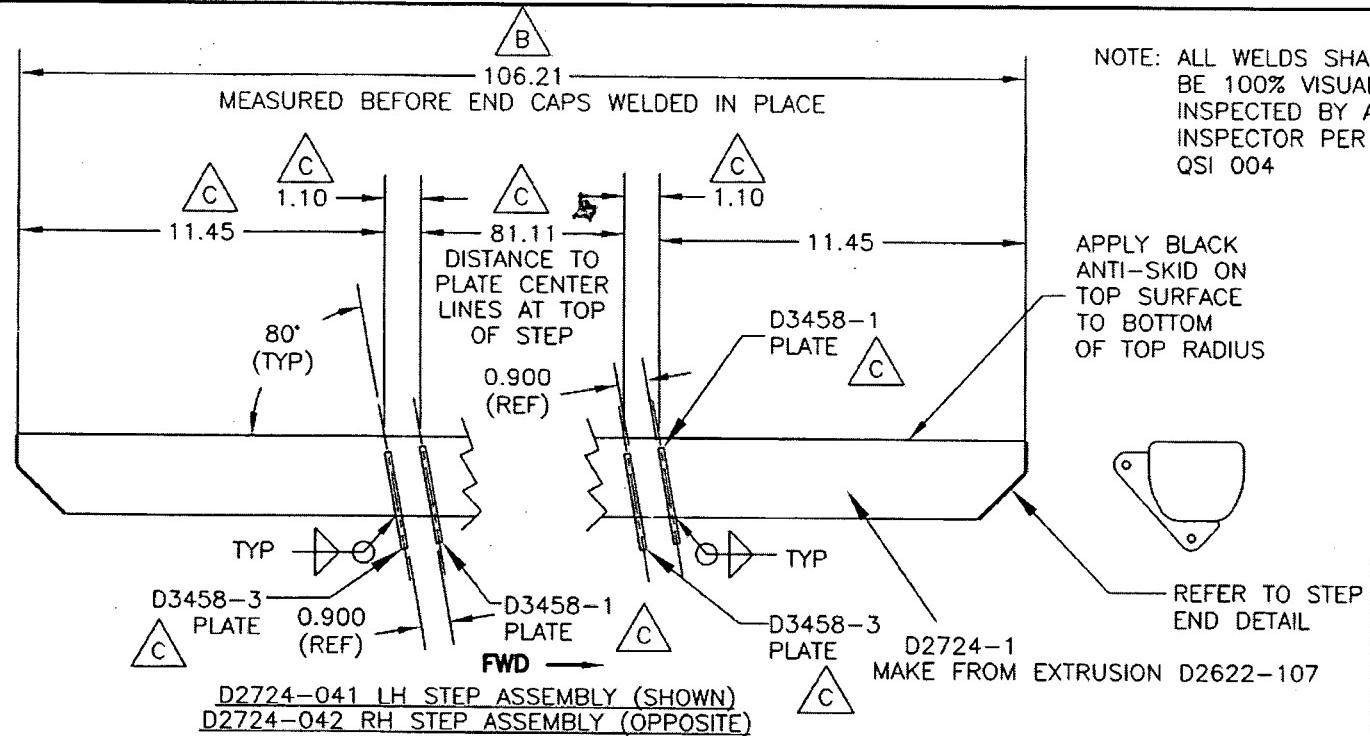
CLOT11101

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



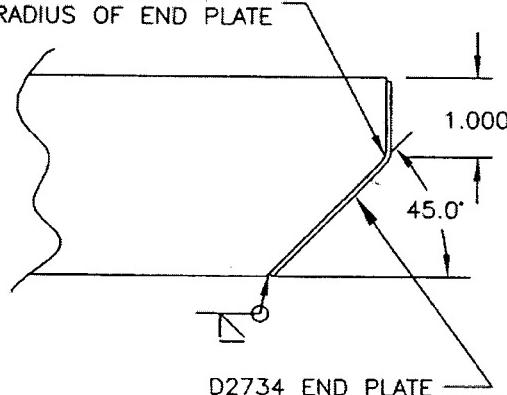
RELEASED  
05/11/14

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2724
DATE 05.09.19	TITLE 206L/407 STEP ASSEMBLY	REV. C SHEET 1 OF 1
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3

### D2724-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34981A  
INCONTROLD COPY  
SHOP COPY  
RETURN TO  
ENGINEERING



TYPICAL STEP END DETAIL  
NOT TO SCALE

B

### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED